

Work Order ID 63870

November 17, 2010 1:06:37 PM



Page 1

Item ID: D3001-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 11/17/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 10/11/17 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3001	Rev B

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3001

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B10-11-17

(10)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 10/11/10

(X)

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Scuff surfaces with 80grit sandpaper per QSI 006
2-Deburr.

=> Mark 10/11/25

(10X)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/11/10

(X)

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Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

=> Jyl 10/11/26

x10

d

Hand Finishing

Memo

0.00

160



QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

10 BF 10-11-26

170



Packaging

Identify as per dwg & Stock Location: 178

0.00

Packaging

Memo

0.00

C 10/11/26 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK

10/11/29

MF
10-11-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 63870



Parent Item: D3001-1



Parent Item Name: Doubler

Start Date: 11/17/10

Required Date: 11/19/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 01.03.22 New Issue EC
IPP rev.B added scuffing NCR 061 EC
IPP Rev:C Now On Waterjet 07-12-13 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040		Purchased	No			100	sf	32.3234	0.7083	7.455789			
---------------	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--



5052-H32 .040 Sheet

10-11-17

Location

Loc Qty

Loc Code

MAT	23.8	
114488	23.8	
MAT23	8.5234	
101875	1.5	
109058	5.6234	
113123	1.4	

114489

10

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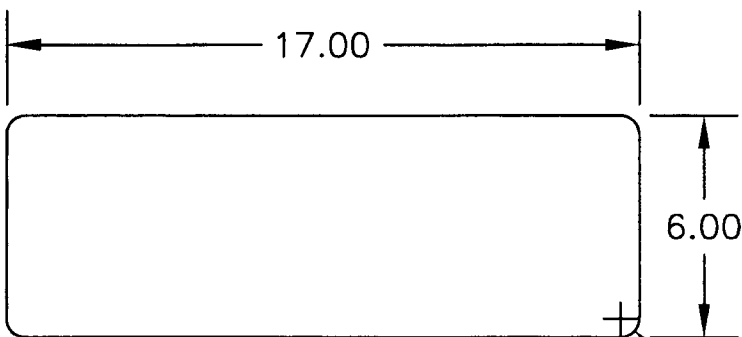
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART

RELEASE
06.11.03

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. B
99	CB		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
X	X	D3001	SCALE
DATE		TITLE	1:5
06.10.06		DOUBLER	
A	01.03.21	NEW ISSUE	
B	06.10.06	ADD BONDING PREP NOTE	



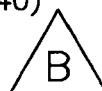
R0.50 (TYP)

D3001-1 DOUBLER

C21011117
W10:63870

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32/H34 SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.040)
OR ALUMINUM 6061-T6 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) PREPARE FOR BONDING TO COMPOSITE STRUCTURE
PER DART QSI 006 4.10
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS TO 0.010 MAX



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